











Work Order ID 52479

September 25, 2009 1:44:24 PM

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Item ID:	PB67-43001-11 GN	Accept		Setup	Start	
Revision ID:	B1				Stop	
Item Name:	Fwf Adjustable Blade Support Assembly					
Start Date:	10/05/2009	Start Qty:	2.00		Cust Item ID:	
Required Date:	10/16/2009	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	ME	Date:	09-09-25	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	Rev B1								
100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- make a 0.090" chamfer in the 1.00" hole before welding 2- assemble parts and weld as per dwg								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
									
QC	Memo	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									

Pl 09 10 08

10 09-10-08

=> 5 02/10/08

(12) 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: PB67-43001-11
 Revision ID: B1
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 Required Date: 10/16/2009 Req'd Qty: 2.00
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Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo 1- grind weld flush in area of PB67-43001-249 only □ 2- install helicol insert as per dwg	0.00							
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							

QPL 09 10 13

275 02/01/13

(f2) /

4/15/13

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries




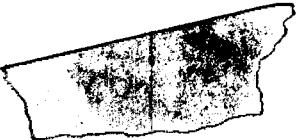
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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 Memo 1- MASK TUBE FROM BASE TO GUSSET 4:13 LOVEN TEMPERATURE: 320 TIME: 4:45	0.00 0.00							M18144 M-L 09/10/14 (2X)
170  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							09-10-20 (2)
180  Small Fab Small Fab	Small Fab Memo 1- match drill cover to existing holes in support 2- assemble as per dwg	0.00 0.00							09 10 20 

W/O:		WORK ORDER CHANGES					
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Required Date: 10/16/2009 Req'd Qty: 2.00

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00				(X2)			
200 	Identify as per dwg & Stock Location: <i>lp</i>	0.00							
Packaging Packaging	Memo	0.00							
210 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

2> 802/10/21

lp 09 10 21

09/10/21
mk
09-10-21

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 52479

Parent Item: PB67-43001-11RevB1

Parent Item Name: Fwf Adjustable Blade Support Assembly


Start Date: 10/05/2009

Required Date: 10/16/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS124780  HELICAL INSERT		Purchased	No			180	Each	96.0000	2.0000			

SAI 09-10-13

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

96

111064

96

2

MS27039-1-10

Purchased

No

180

Each

37.0000

16.0000



Screw



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

37

111425

37

NAS1149F0316P

Purchased

No

100

Each

124.0000

16.0000



WASHER



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

124

111117

119

111124

5

~~NAS1149F0332P~~ (16)

~~09-10-20~~

M112940

(16) 09-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 52479

Parent Item: PB67-43001-11RevB1

Parent Item Name: Fwf Adjustable Blade Support Assembly


Start Date: 10/05/2009

Required Date: 10/16/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-247RevB1		Manufactured	No			100	Each	4.0000	2.0000			
												
Inner Tube												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

4

44985

4

PB67-43001-249RevB1

Manufactured No

100

Each

0.0000

2.0000



Inner Tube Bushing

PB67-43001-253RevB1

Manufactured No

100

Each

12.0000

2.0000



Gusset

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

12

44983

12

PB67-43001-254RevB1

Manufactured No

100

Each

2.0000

2.0000



Gusset

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2

44982

2

Ppl 09.10.07 ✓

*②
352480 → 2 Ppl 09.10.07 **

Ppl 09.10.07

*② ✓
Ppl 09.10.07*

*SK
② ✓*

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Fwf Adjustable Blade Support Assembly





Start Date: 10/05/2009

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Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-67RevB1		Manufactured	No			130	Each	0.0000	2.0000			
												
PB67-43001-67												
PB67-43001-69RevB1		Manufactured	No			180	Each	1.0000	2.0000			
												
90 Degree Cover Plate												

*
B52634 → 2 P109.0.07

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

45762

1

52453

x2 MF 09-10-21

1

PB67-43001-83RevB1

Manufactured No

180

Each

6.0000

2.0000



PB67-43001-83

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

47042

6

6

B52418 → 2 P109.10.20

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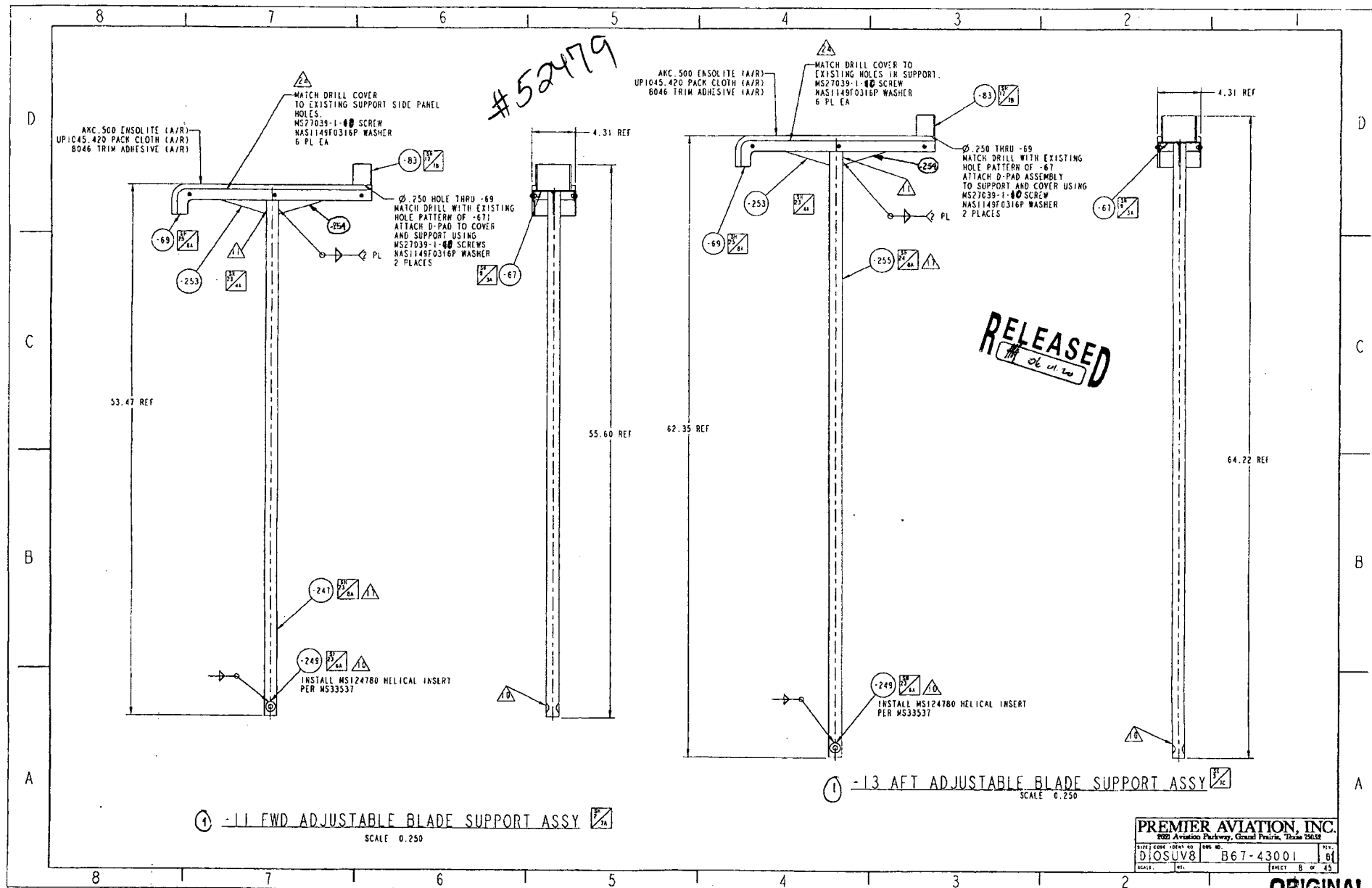
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ORIGINAL

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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